She Mon 1405

QC2- Inspect parts off machine FAI/FAIB

Memo

Quality Control

	ons	man 1995			/	*				
Work Orden Thursday, May 12	r <b>ID 69572</b> 2, 2011 11:19:10 AM	•				•	. =	·		Page
Revision ID:	D3199-4 Bracket, Fwd RH		Accept				s	Setup Sta		
Start Date: 5 Required Date: 5 Reference:	/12/2011 Start Qty: / /16/2011 Req'd Qty:		/18// 1881   1881   1881   1881   1881	Cust Item I Customer:	D:					
	Process Plan: QC:	Date: Date:	Tooling: SPC (Y/N):		ate:		F	tun Sta Sto		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				···					
D3199	D	<del>-</del>								
100 	FLOW WATER	JET	0.00							
Waterjet FLOW CNC Waterjet	Dwg Prog	as per Dwg D3199 g Rev: D g Rev: D burr if required	0.00				¶\$1L	-5 <u>-17</u>		
	Det	our ii iequiieu								

0.00

0.00

B11-5-12

DATE STEP PROCEDURE CHANGE  Part No:PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC	ty Approval Chief Eng / Prod Mgr Appro QC Inspe
Part No:PAR #:Fault Category:NCR: Yes No DQA:	ty Chief Eng / Chief
Resolution: Disposition: QA: N/C Closed:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A	
Resolution: Disposition: QA: N/C Closed:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A	
Resolution: Disposition: QA: N/C Closed:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A	
Resolution: Disposition: QA: N/C Closed:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A	
Resolution: Disposition: QA: N/C Closed:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A	
NCR:  WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B  Section A  Description of NC Section A  Initial Action Description Sign & Section C	Date:
DATE STEP Description of NC Section A Section B Initial Action Description Sign & Section C	Date:
DATE STEP Description of NC   Initial   Action Description   Sign & Section C	
Section A minual Action Description Section (	
	Chief Eng QC Insp

Thursday, May 12, 2011 11:19:10 AM

Item ID:

D3199-4

Accept



Setup Start

Stop



Revision ID:

Item Name:

Bracket, Fwd RH

**Start Date:** 

5/12/2011

Start Qty: 4.00 Reg'd Qty: 4.00

**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Required Date: 5/16/2011

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

0.00

0 11/05/13

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

130



Brake NC

Bend as per dwg

Small Fab

Memo

Memo

0.00

0.00

SB 11/05/13

140



Quality Control

QC5- Inspect part completeness to step on W/O

	•									
W/O:		<del></del>	: WO	RK ORDER CHAI	NGES			·		
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					٠					
					1					
Part No	:	PAR #:	Fault Categ	jory:	NCI	R: Yes I	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	1:	QA:	N/C Clo	sed:	<b>b</b>	Date: _	
NCR:			WORK ORDE	R NON-CONFOR	MANCE	(NCR	)			
DATE	STEP	Description of NC			Section B	0:		cation	Approval	Approval
	3127	Section A	Initial Chief Eng	Action Description Chief Eng	on ·	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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	·	· .								
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Work Ord Thursday, May						,		-	Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3199-4  Bracket, Fwd  5/12/2011  2: 5/16/2011	RH Start Qty: 4.00 Req'd Qty: 4.00		Accept	Cust Item ID: Customer:	<b>                                     </b>	Setup	Stop	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	
Sequence ID/ Work Center 150 Powdercoat Powder Coating	id 5128	Operation Description Grey Sandtex(Ref:4,3.5.4)  Memo START TIM OVEN TEM FINISH TIM	16: 10 5 50 IPERATURE: 32 (	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Acce Code Qty	ept Ro Q		Reject Insp. Number Stamp
160 QC		QC3- Inspect Part Finish  Memo		0.00			(1/3	13	SVFD

170

Packaging

Quality Control

Packaging

Identify as per dwg & Stock Location 336

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-					1 roa wigi	
Part No		PAR #:							
	Н	esolution:						Date:	
NCR:			WORK ORI	DER NON-CONFORM	•	,n)			<b></b>
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	tion B Sigr		erification Section C	Approval Chief Eng	Approval
		Section A	Chief Eng	Chief Eng	Dat		Section C	Chief Eng	QC Inspector
				*					,
,									
								,	

## Work Order ID 69572 Thursday, May 12, 2011 11:19:10 AM

Item ID:

D3199-4

**Revision ID:** 

Item Name:

Bracket, Fwd RH

**Start Date:** Required Date: 5/16/2011

5/12/2011

Start Qty: 4.00

Req'd Qty: 4.00

Accept



Setup Start

Stop

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Memo

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start



Stop

Sequence ID/ Work Center ID

180

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Date:

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Run

Insp. Reject Number Stamp

W/O:			WO	RK ORDER CHAN	IGES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	,	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No	*	PAR #:	Fault Categ	jory:	NCR:	Yes N	10 <b>DQ</b>	<b>\</b> :	Date:	
	Reso	olution:	Disposition	):	QA: N	I/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (	NCR)				•
DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Section	on C	Chief Eng	QC Inspector
										·

#### **Picklist Print**

Thursday, May 12, 2011 11:19:08 AM

Work Order ID: 69572

Parent Item:

D3199-4

Parent Item Name:

Bracket, Fwd RH



Start Date: 5/12/2011

Required Date: 5/16/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

1PP RevA: RevC-prelim DD verified by:EC 11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No	e e me € se me memor con . v second ve con		100	sf	86.7000	0.1673	0.704421	1.5		
											511-5-	1.	

304/316 .040 Sheet

Location	Loc Qty	Loc Code	
MAT020	86.7		
116623	0.2		,
117550	86.5		17550

W/O:			WC	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DC	A:	Date: _	
	R	esolution:	Disposition	ı:	QA: N/C	Closed:		Date: _	
NCR:	-		WORK ORDI	ER NON-CONFORM	IANCE (NC	R)			
DATE	STEP	Description of NC			ction B	Verif	cation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector
-									
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					^				

DART AEROSPACE LTD	Work Order:	69572
Description: Bracket	Part Number:	D3199-4
Inspection Dwg: D3199 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.615	+/-0.010	,615	h		V BOZ	
0.295	+/-0.010	896,	X		V	
0.500	+/-0.010	,500	4		V	
2.750	+/-0.010	2.748	ъ		V	
4.030	+/-0.010	4.032	20		V	,
8.030	+/-0.010	8.042	۶		V	
0.990	+/-0.010	. 994	ķs.		V	
3.00	+/-0.030	3,002	X		V .	1
3.64	+/-0.030	3.648	b		Υ	
4.02	+/-0.030	4.017	b		V	<i>y</i>
0.040	+/-0.010	ملاه.	×		V	
in the second se						(
						J
				-		

Measured by:	Audited by:	Preliminary Approval:
Date: 11-5-1	Date: 100-/12	Date:

Rev	Date	Change	Revis	ed by	Approved
Α	10.12.21	New Issue	KJ	۱Δ	/1
В	11.04.06	Dimensions updated per Dwg Rev D	KJ	-XX	AX.
				777	

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1.500 1.830 R0.30 TYP D BEND LINES REF R0.01 R0.105 2.971 GRAIN DIRECTION 4PL TYP 2.29 2.015 REF 0.575 1.00 1.090 REF 0.315 0.400 4.030 **D3199-1F FLAT PATTERN** R0.17 0.41 R0.25 2.24 RELEASED 2011-03-32 D3199-1 BRACKET MADE FROM D3199-1F RE-DESIGNED 03199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-79 11.03.21 ADD -3/-4 PART (SHEET 2-4) С 09.11.19 HS В 2.24 WAS 2.142; ADD FINISH; UPDATE DWG CB 1 06.11.01 A NEW ISSUE CP 03.08.05 NOTES:
1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304520GA
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART OSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH REV DESCRIPTION θY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. D D3199 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE **BRACKET** DE APPR. NTS COPYRIGHT @ 2003 BY DART AEROSPACE LTD DATE

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11.03.21

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NOTE ORIENTATION OF HOLES WHEN BENDING - R0.17 2.03 REF 2.24 2.75 REF -- 0.49 REF D3199-3 BRACKET MADE FROM D3199-3F DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN DRAWING NO. CHECKED REV. D SHEET 2 OF 4 D3199 MFG. APPR. TITLE APPROVED SCALE **BRACKET** DE APPR. DATE 11.03.21

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2 NOTE ORIENTATION OF HOLES WHEN BENDING - R0.17 2.03 REF 2.24 \_2.75\_ REF REF 1 D3199-4 BRACKET MADE FROM D3199-3F DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. D MFG. APPR. SHEET 3 OF 4 TITLE APPROVED SCALE BRACKET DE APPR. NTS DATE 11.03.21

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D \_29° BEND LINE REF GRAIN DIRECTION 3.00 2.31 2.07 REF TYP 0.615 TYP 0.990 0.295\_] TYP \_R0.125 TYP R0.13 \_R0.30 0.500 8 PL - 8.030 -**D3199-3F FLAT PATTERN** 

NOTES: 1) MATÉRIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 28 FINISH PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA

REF DART SPEC M304S20GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.26 lbs

DESIGN .		DART AEROSPACE LTD		
DRAWN	A	HAWKESBURY, ON		
CHECKED	AJ5	DRAWING NO.	REV. D	
MFG, APPR.	W	D3199	SHEET 4 OF 4	
APPROVED	10	TITLE	SCALE	
DE APPR.	-#-	BRACKET	NTS	
DATE 11.0	3.21	COPYRIGHT © 2003 BY DART AEROSPACE LTD THE TOCHNICH BY PRIVATE AND CHRESTING A HIGH SEMPLES ON THE SPREED COMPINION THAT IT HE HIGH TO BE UNDED THE ARE THE TOOK OF CHORDING ON COMMENTATION TO ANY CHARLES HE SHOW WITHOUT		

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